

Date: Thursday, 2/21/2008 9:26:05 AM  
User: Kim Johnston

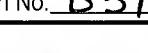
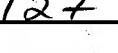
## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 37565		Part Number	: D2572		
Estimate Number	: 10531		Drawing Number	: D2572 REV E		
P.O. Number	:		Project Number	: N/A		
This Issue	: 2/21/2008	S.O. No.	Type	: MACHINED PARTS		
Prsht Rev.	: NC		Drawing Revision	: E		
First Issue	: / /		Material	:		
Previous Run	: 37283		Due Date	: 3/15/2008		
Written By	:		Qty:	10	Um:	Each
Checked & Approved By	: <u>11080221</u>					
Comment	: Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ					

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	7075-T7351 8.25X5.0X2.5
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)	
	7075-T7351 8.25X5.0X2.5	
	Make from D6101-005 billet for D2572	
	Ensure that grain is along 5.00" length	
	Batch No: <u>B31388</u> +1	<u>7/2 08/21/27</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		

Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 51 Double check by: J.P.

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

## CONVENTIONAL MILLING MACHINES



#### Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/03/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2572 PAR #: N/A Fault Category: Prod / Machined part NCR: Yes No DQA: D Date: 08/04/15  
D412-742 QA: N/C Closed: D Date: 08/04/15

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/26	2.0	One saddle is scrap because the hole location is off by .050" The dimension of .500±.010" was .438.	<u>Initial</u> <u>08/04/15</u>	Scrap and Destroy AND Reute <u>Qty 50</u> <u>B# 31388</u>	<u>8/1</u> <u>08/03/26</u>	<u>Initial</u> <u>08/03/26</u>	<u>Initial</u> <u>08/04/26</u>	<u>Initial</u> <u>08/03/26</u>
		R.C. Origin was not take properly. operator error.						

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 37565

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

20 08/04/02

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(10X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M/L

08/04/02

7.0 POWDER COATING POWDER COATING



(D)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107550

BL 08-04-03

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



(10)

Comment: INSPECT POWDER COAT

08-04-07

9.0 PACKAGING 1 PACKAGING RESOURCE #1



(10)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

STG32 08/04/03 (10)

08/04/08  
JY

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

W 08/04/04

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 37565	
Description: Saddle, Fwd Inboard				Part Number: D2572	
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	<del>DT8682</del>	.441	.441	.442	.442		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.000		
F	0.490	0.510		.501	.500	.502	.501		
G	0.257	0.262	<del>DT8683</del>	.258	.258	.258	.257		
H	0.375	0.380	<del>DT8684</del>	.376	.376	.376	.376		
I	0.490	0.510		.502	.500	.505	.505		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.571	.573	.571	.571		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.500	1.500	1.500	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.885	3.875	3.874	3.874		
P	0.115	0.135		.126	.127	.127	.127		
Q	0.115	0.135		.125	.135	.135	.135		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.126	.127	.127	.127		
T	0.178	0.198		.181	.181	.181	.181		
U	2.940	2.980		2.960	2.960	2.960	2.962		
V	0.230	0.250		.233	.234	.237	.240		
W	0.115	0.135		.130	.130	.125	.121		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.762	.762	.762	.760		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.628	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.389	1.385	1.385	1.385		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.250	.250	.250	.253		
AH	0.240	0.260		.246	.249	.249	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	8f	Audited by:	19
Date:	08/03/02	Date:	08/04/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



DART AEROSPACE LTD				Work Order:	37565
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	51	62	73	84	By	Date
A	0.438	0.443	<del>DT8682</del>	.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.502	.503	.503	.502		
G	0.257	0.262	<del>DT8683</del>	.258	.258	.258	.258		
H	0.375	0.380	<del>DT8684</del>	.377	.377	.376	.376		
I	0.490	0.510		.505	.501	.501	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.577	.570	.570	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.494	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.875		
P	0.115	0.135		.125	.125	.126	.126		
Q	0.115	0.135		.135	.135	.131	.135		
R	0.240	0.260		.252	.252	.252	.251		
S	0.115	0.135		.130	.130	.126	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.962	2.962	2.961		
V	0.230	0.250		.239	.240	.239	.240		
W	0.115	0.135		.135	.130	.130	.130		
X	0.307	0.312		.309	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.629	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.381	1.384	1.385	1.385		
AF	0.115	0.135		.135	.135	.136	.135		
AG	0.240	0.280		.248	.250	.250	.250		
AH	0.240	0.260		.257	.257	.240	.240		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: *85*  
Date: *08/03/27*

Audited by: *RP*  
Date: *08/04/27*

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>20</i>	<i>20</i>

DART AEROSPACE LTD				Work Order:	37565
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	<del>DT8682</del>	.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		.501	.501				
G	0.257	0.262	<del>DT8683</del>	.258	.260				
H	0.375	0.380	<del>DT8684</del>	.377	.378				
I	0.490	0.510		.501	.500				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.570	.570				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.500	1.500				
N	2.495	2.505		2.500	2.499				
O	3.869	3.879		3.874	3.872				
P	0.115	0.135		.126	.125				
Q	0.115	0.135		.127	.135				
R	0.240	0.260		.252	.257				
S	0.115	0.135		.127	.130				
T	0.178	0.198		.184	.188				
U	2.940	2.980		2.962	2.960				
V	0.230	0.250		.240	.241				
W	0.115	0.135		.127	.120				
X	0.307	0.312		.309	.309				
Y	0.760	0.765		.760	.766				
Z	0.352	0.372		.362	.365				
AA	0.470	0.530		.520	.500				
AB	0.615	0.635		.630	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250	.250				
AE	1.375	1.395		1.385	1.384				
AF	0.115	0.135		.125	.135				
AG	0.240	0.280		.255	.253				
AH	0.240	0.260		.250	.252				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				

Accept/Reject

Measured by:	8-5	Audited by:	RD
Date:	08/03/21	Date:	08/04/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

